

Work Order ID 81494

81494

Page 1

March-14-12 4:23:03 PM

Item ID: D3213-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 14/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 28/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/14 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3213	B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520								
	Identify as D3213-041								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>7:40</u> OVEN TEMPERATURE: <u>320</u>								
	FINISH TIME: <u>8:10</u>								

M117338

320

8:10

8x 12/05/22

8x

8x 12/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81494

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

8

Cust Item ID:

8

Customer:

Reference:

Run Start *NR1*

Date:

Tooling: _____ **Date:** _____

Date:

SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

130

QC

Memo

0.00

Quality Control

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3213

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81494

81494

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March-14-12 4:23:03 PM

Item ID: D3213-041

Accept:

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly

Start Date: 14/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 28/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160 Identify as per dwg & Stock Location

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21 - Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/5/29
MW 12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 4:23:07 PM

Page 1

Work Order ID: 81494

81494

Parent Item: D3213-041

D3213-041

Parent Item Name: Door Assembly

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3161-3 Manufactured No

D3161-3

Hinge 15.0"

Location

Loc Qty

Loc Code

ST031

10

74504

2

76201

8

D3213-1 Manufactured No

D3213-1

Door Panel

Location

Loc Qty

Loc Code

ST232A

22

74026

2

74538

20

D3213-3 Manufactured No

D3213-3

Door Panel

Location

Loc Qty

Loc Code

ST232A

23

68907

2

74027

9

74539

12

**

**

**

EP 12/05/22

2
8
B 82176 (60)

EP 12/05/22

2
6

EP 12/05/22

8
9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 81494

81494

Parent Item: D3213-041

D3213-041

Parent Item Name: Door Assembly

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 8.00

Required Qty: 8.00

MS20470AD4-6

Purchased

No

100

Each

2,497.000

1

8

MS20470AD4-6

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

2497

117395

16

118927

386

119109

12

119546

595

120142

1488

D2137

Manufactured

No

140

Each

22.0000

1

8

D2137

Decal - No Step

**

Location

Loc Qty

Loc Code

GA

22

76064

2

79837

20

D2419

Manufactured

No

140

Each

2.0000

1

8

D2419

Handle

**

Location

Loc Qty

Loc Code

GA

2

80809

2

D2462

Manufactured

No

140

f

356.8004

2.4

19.2

D2462

Seal

**

Location

Loc Qty

Loc Code

ST404

356.8004

48530

356.8004

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 81494

81494

Parent Item: D3213-041

D3213-041

Parent Item Name: Door Assembly

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 8.00

Required Qty: 8.00

D2728-1 Manufactured No

D2728-1

Dart Logo label

MS20470AD4-4

Purchased No

MS20470AD4-4

Rivet, Universal Head

140 Each 0.0000 0 0

**

140 Each 4,967.000 24 192

**

Location

Loc Qty

Loc Code

ST319

4967

116188

136

116391

66

118614

1087

119109

26

120361

1858

120518

794

121011

1000

NAS1149DN632J

Purchased No

NAS1149DN632.I

Washer

140 Each 416.0000 1 8

**

Location

Loc Qty

Loc Code

ST298

416

118428

416

March-14-12 4:23:07 PM

Shop Packet Print

Page 3

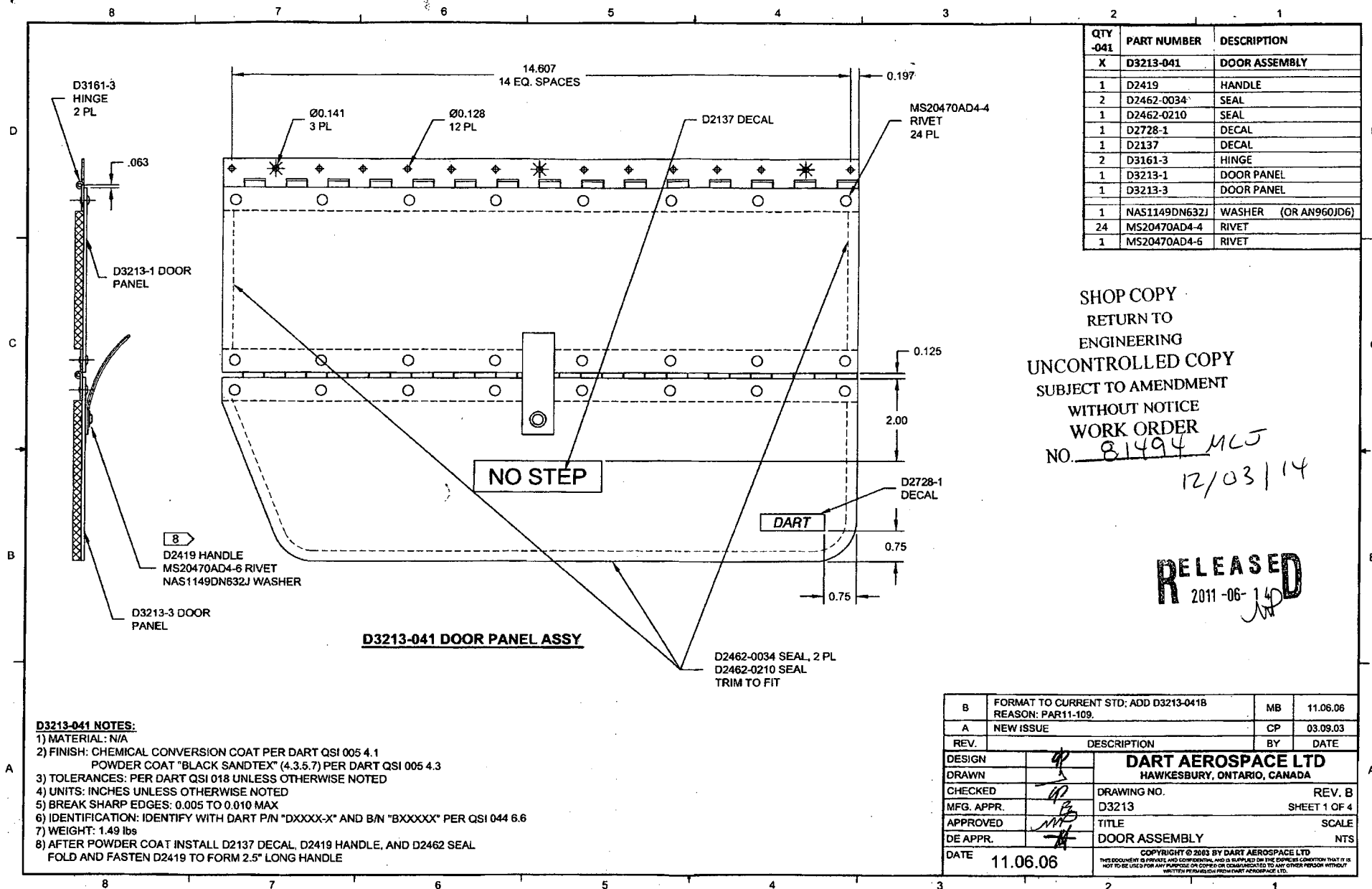
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	PART NUMBER	DESCRIPTION
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 81494 MLC
12/03/14

RELEASED
 2011-06-14

B	FORMAT TO CURRENT STD: ADD D3213-0418 REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>	DRAWING NO.	REV. B
CHECKED	<i>JP</i>	D3213	SHEET 1 OF 4
MFG. APPR.	<i>JP</i>	TITLE	SCALE
APPROVED	<i>JP</i>	DOOR ASSEMBLY	NTS
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DATE	11.06.06		

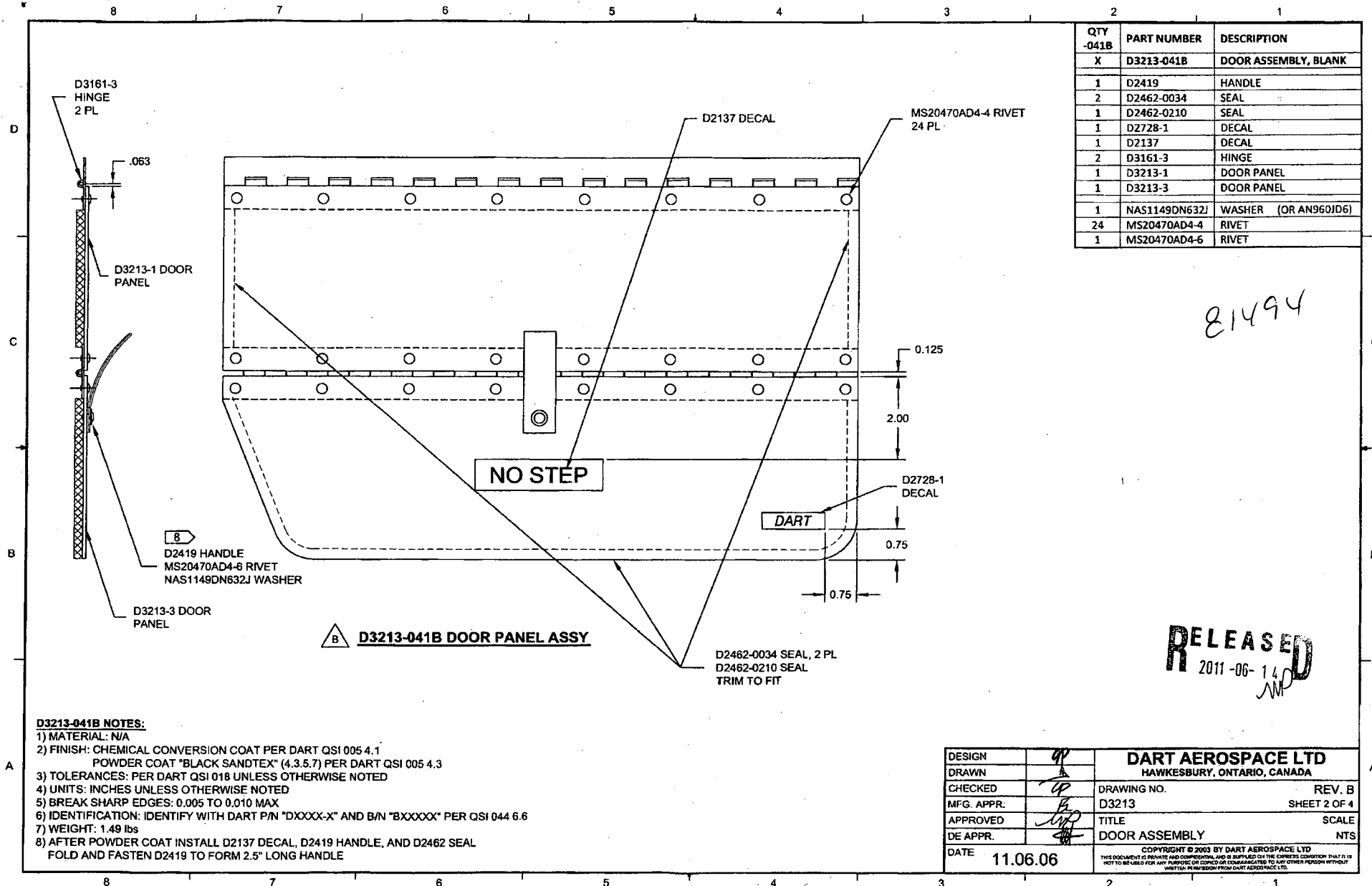
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	9P	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D3213	SHEET 2 OF 4
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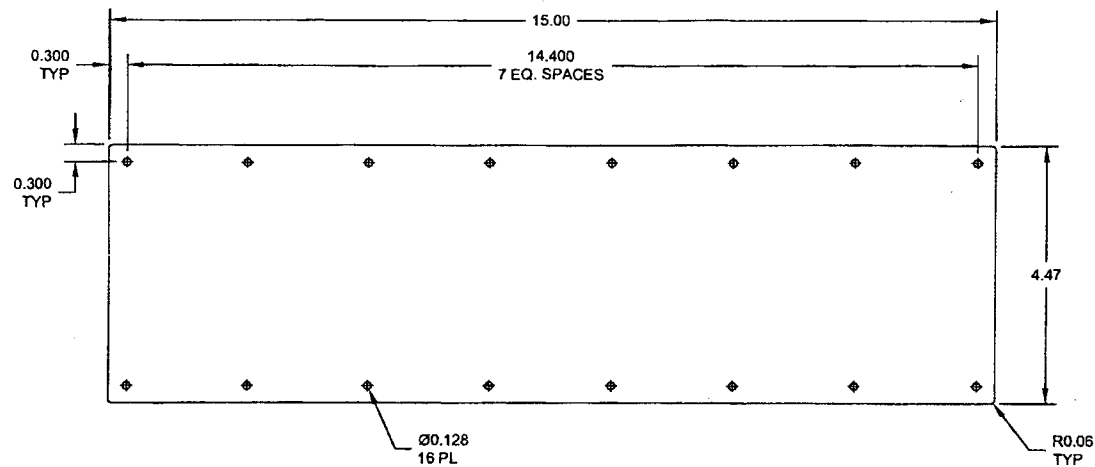
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3213-1 DOOR PANEL

RELEASED
2011-06-16

D3213-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
DATE	11.06.06	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

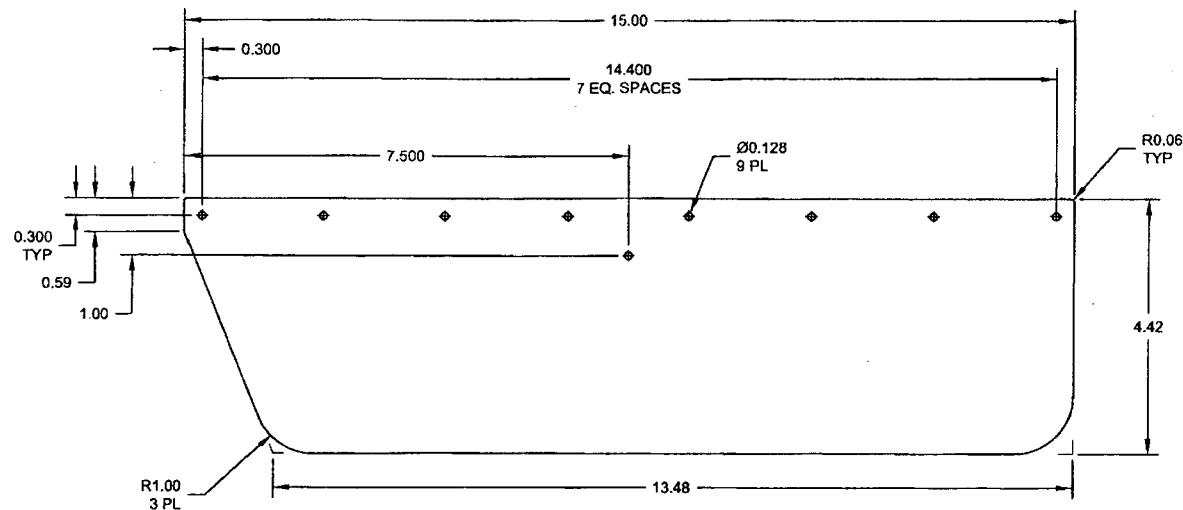
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3213-3 DOOR PANEL

D3213-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.39 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3213	SHEET 4 OF 4
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RELEASED
2011-06-10
NR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries